

*Backed
log per*

Work Order ID 55485

January 19, 2010 1:31:36 PM



Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 1/19/10 Start Qty: 20.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

RP

Date: 10-1-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

B 10-1-20

20

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

only SF 10/01/24

19

1

PTO

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SF 10/01/24

19

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2432 PAR #: _____ Fault Category: Small FAB / Water Jet / Machined parts NCR: Yes No DQA: 1 Date: 10-02-10
 Resolution: A Scrap / B Accepted Disposition: A Scrap / B Use as is. QA: N/C Closed: 1 Date: 10/02/11

NCR: 55485		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/25	130	One Blank Material was Too Short Before cutting on water jet R.L. Placement on w/s for cutout / Process	<u>10/01/25</u>	→ SCRAP + Dating no Replce QTY 1	<u>SB</u> <u>10/01/25</u>	<u>10/02-10</u>	<u>10/01/25</u>	<u>10/01/25</u>
	130	DIMENSION "V" 0.375 ± 0.010 SOME BEHINDS 0.386 - 0.388	<u>HA</u>	ACCEPTABLE AS IS.	<u>SB</u> <u>10/01/29</u>	<u>10/02-10</u>	<u>10/01-29</u>	<u>10/02-10</u>

NOTE: Date & initial all entries

Work Order ID 55485

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Page 2

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 1/19/10 Start Qty: 20.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

DIP
10/01/29

19

151

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

PP1
55484

10/02/01 (19)

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/03 (19)

MF 10-02-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 19, 2010 1:31:40 PM

Page 1
1

Work Order ID: 55485

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw


Comments:

Start Date: 1/19/10

Required Date: 1/25/10

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	431.9957	74.0000			
												
UHMW 1" Black												



18 10-120

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	400.248	
112186	122.0164	
113166	76.1264	
113591	202.1052	
Main Warehouse		
ST	31.7477	
111354	31.7477	

113591

20

b4

69,4752

48248

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55485
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432		Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063	✓			
B	5.500	+/-0.030	5.505	✓			
C	0.200	+/-0.030	.199	✓			
D	0.25 x 45°	+/-0.030	.25	✓			
E	R0.250	+/-0.030	.250	✓			
F	0.250	+/-0.010	.260	✓			
G	0.625	+/-0.030	.630	✓			
H	0.375	+/-0.010	.384	✓			
I	0.950	+0.030/0.010	.962	✓			
J	19.000	+/-0.030	19.00	✓			
K	3.14	+/-0.030	3.130	✓			
L	3.28	+/-0.030	3.280	✓			
M	Ø0.260	+0.005/-0.000	.260	✓			
N	Ø0.93	+/-0.030	.920	✓			
O	0.30	+0.030/-0.000	.314	✓			
P	23.750	+/-0.030	23.750	✓			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.250	✓			
S	2.000	+/-0.030	2.016	✓			
T	9.000	+/-0.010	9.000	✓			
U	9.000	+/-0.010	9.000	✓			
V	0.375	+/-0.010	.383	✓			

Measured by:	LP
Date:	10/01/29

Audited by:	DJP
Date:	10/01/29

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

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SUBJECT TO AN
WITHOUT N
WORK OF
NO. 55485

DART



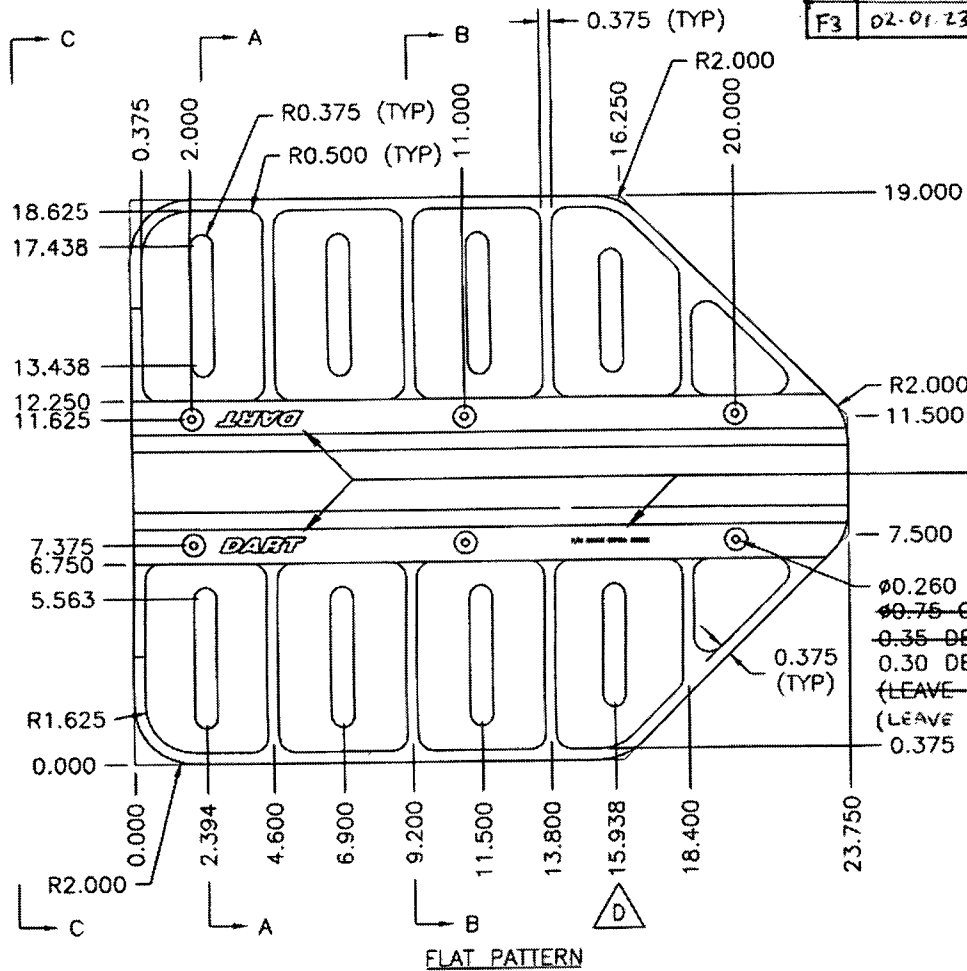
REV 10-1-10

RELEASED
93.06.12 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED KE	DRAWING NO. D2432
DATE 98.05.12	TITLE BEARPAW	REV. F SHEET 1 OF 2
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



EFFECTIVE	DEOS
9143	

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

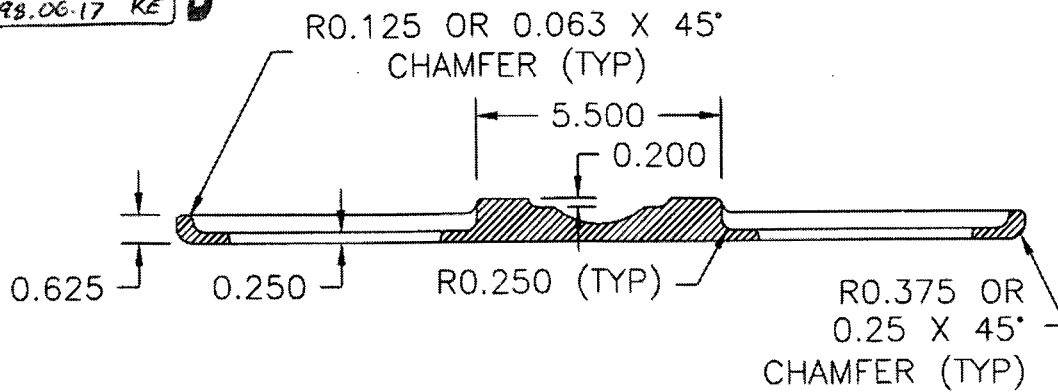
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)



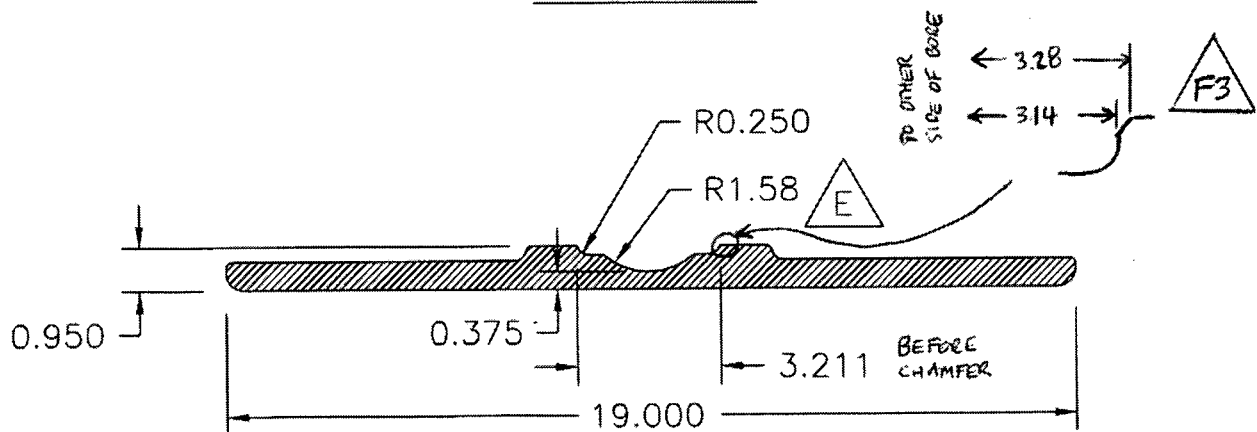
W/D 55485

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

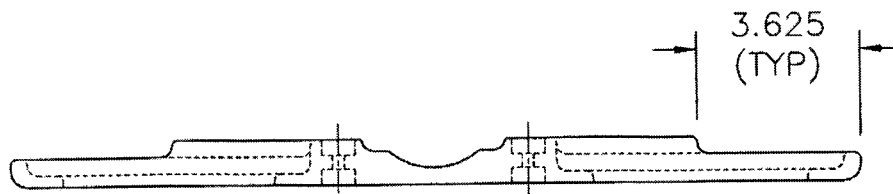
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C